

This Page Is Inserted by IFW Operations
and is not a part of the Official Record

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images may include (but are not limited to):

- BLACK BORDERS
- TEXT CUT OFF AT TOP, BOTTOM OR SIDES
- FADED TEXT
- ILLEGIBLE TEXT
- SKEWED/SLANTED IMAGES
- COLORED PHOTOS
- BLACK OR VERY BLACK AND WHITE DARK PHOTOS
- GRAY SCALE DOCUMENTS

IMAGES ARE BEST AVAILABLE COPY.

**As rescanning documents *will not* correct images,
please do not report the images to the
Image Problem Mailbox.**

PCT

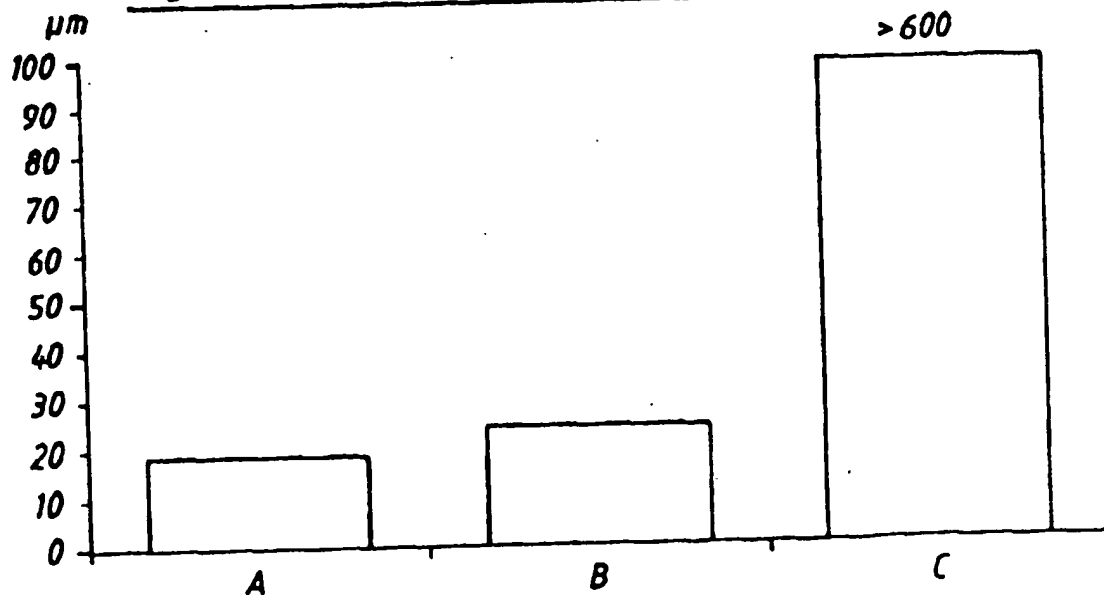
WORLD INTELLECTUAL PROPERTY ORGANIZATION
International Bureau



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification 6 : C07D 401/12, A61K 31/44		A1	(11) International Publication Number: WO 95/01977
			(43) International Publication Date: 19 January 1995 (19.01.95)
(21) International Application Number: PCT/SE94/00680		(81) Designated States: AM, AT, AU, BB, BG, BR, BY, CA, CH, CN, CZ, DE, DK, ES, FI, GB, GE, HU, JP, KE, KG, KP, KR, KZ, LK, LT, LU, LV, MD, MG, MN, MW, NL, NO, NZ, PL, PT, RO, RU, SD, SE, SI, SK, TJ, TT, UA, US, UZ, VN, European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG), ARIPO patent (KE, MW, SD).	
(22) International Filing Date: 8 July 1994 (08.07.94)		<p>Published With international search report.</p>	
(30) Priority Data: 9302396-8 9 July 1993 (09.07.93) SE			
(71) Applicant (for all designated States except US): ASTRA AKTIEBOLAG [SE/SE]; S-151 85 Södertälje (SE).			
(72) Inventors; and (75) Inventors/Applicants (for US only): KÄLLSTRÖM, Lars, Åke [SE/SE]; Rönnbärsvägen 3, S-152 52 Södertälje (SE). NYGREN, Monica, Annelie [SE/SE]; Myrstigen 21, S-151 60 Södertälje (SE).			
(74) Agent: LARSSON, Birgitta; Astra Aktiebolag, Patent Dept., S-151 85 Södertälje (SE).			
(54) Title: MAGNESIUM OMEPRAZOLE			

Magnesium omeprazole - Mean Mass Diameter



(57) Abstract

A novel compound form of magnesium omeprazole useful in the manufacture of pharmaceutical formulations, the use of the product and the process for its production are described.

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AT	Austria	GB	United Kingdom	MR	Mauritania
AU	Australia	GE	Georgia	MW	Malawi
BB	Barbados	GN	Guinea	NE	Niger
BE	Belgium	GR	Greece	NL	Netherlands
BF	Burkina Faso	HU	Hungary	NO	Norway
BG	Bulgaria	IE	Ireland	NZ	New Zealand
BJ	Benin	IT	Italy	PL	Poland
BR	Brazil	JP	Japan	PT	Portugal
BY	Belarus	KE	Kenya	RO	Romania
CA	Canada	KG	Kyrgyzstan	RU	Russian Federation
CF	Central African Republic	KP	Democratic People's Republic of Korea	SD	Sudan
CG	Congo	KR	Republic of Korea	SE	Sweden
CH	Switzerland	KZ	Kazakhstan	SI	Slovenia
CI	Côte d'Ivoire	LI	Liechtenstein	SK	Slovakia
CM	Cameroon	LK	Sri Lanka	SN	Senegal
CN	China	LU	Luxembourg	TD	Chad
CS	Czechoslovakia	LV	Latvia	TG	Togo
CZ	Czech Republic	MC	Monaco	TJ	Tajikistan
DE	Germany	MD	Republic of Moldova	TT	Trinidad and Tobago
DK	Denmark	MG	Madagascar	UA	Ukraine
ES	Spain	ML	Mali	US	United States of America
FI	Finland	MN	Mongolia	UZ	Uzbekistan
FR	France			VN	Viet Nam
GA	Gabon				

MAGNESIUM OMEPRAZOLE

Field of the invention

5

The present invention relates to a novel process for manufacturing the magnesium salt of omeprazole; the magnesium salt of omeprazole in a novel physical form, especially the magnesium salt as a product of the novel process; the use of the novel form of the magnesium salt of omeprazole in the manufacture of pharmaceutical formulations; and to the use of the novel form of the magnesium salt of omeprazole in medicine.

10

Background of the invention

15 The compound known under the generic name omeprazole is described i.a. in European patent specification 0005129.

Omeprazole is useful for inhibiting gastric acid secretion and has gastric mucosa protective activity in mammals and man. In a more general sense, omeprazole may be used for prevention and treatment of gastric acid related disorders and gastrointestinal inflammatory diseases in mammal and man, including e.g. gastritis, gastric ulcer and duodenal ulcer.

20

The term "omeprazole" as used in this specification designates the neutral form of the compound, that is the form without a salt forming cation present.

25

Certain salts of omeprazole are described in European patent specification 0124495. In said patent specification the requirements and importance regarding storage stability of pharmaceutical preparations are emphasized. Salts possessing superior properties with regard i.a. to storage stability are described in the said European patent specification.

30

In EP 0124495; examples 5 and 6 disclose the synthesis of a magnesium salt of omeprazole.

5 The isolation and purification in full manufacturing scale of the described magnesium omeprazole salts presents one major problem in that magnesium omeprazole salt crystals are very fragile making processes utilising such crystals less attractive in full scale production. Performing the process without crystallization of the magnesium omeprazole gives a product which is less suitable as a pharmaceutical substance.

10

In order to use the magnesium salt of omeprazole, in this specification denoted magnesium omeprazole, in full manufacturing scale in preparing pharmaceutical formulations primarily for oral administration, such as tablets, it is necessary that said magnesium omeprazole possesses a combination of properties which makes
15 such full scale manufacturing feasible. One object of the present invention is to provide a process for full scale production of magnesium omeprazole. A further object of the present invention is to provide a novel form of the magnesium salt of omeprazole which can be used in full scale manufacturing of pharmaceutical formulations, such as tablets.

20

The combination of physical properties of the novel magnesium omeprazole product of the present invention with respect to the degree of crystallinity, particle diameter, density, hygroscopicity, water content and content of other solvents are favorable and permit the manufacture of magnesium omeprazole in a form which
25 possesses the desired properties.

The novel form of magnesium omeprazole can also be formulated into other forms for oral administration and other types of administration such as rectal administration. Examples of formulations are tablets, pellets, granules, capsules,
30 suspensions and suppositories.

The invention

We now provide a novel form of the magnesium salt of omeprazole exhibiting the desired combination of physical properties. This makes full scale production of
5 magnesium omeprazole as well as full scale production of pharmaceutical formulations thereof feasible.

The novel process for the manufacture of magnesium omeprazole also circumvents the above described manufacturing problems and renders possible the recovery and
10 work-up of the magnesium omeprazole substance in traditional chemical process equipment.

It has been found that the following property is significant to obtain such product:

- 15 a) Crystalline form, with a degree of crystallinity of not less than 70%, preferably higher than 75% as determined by X-ray powder diffraction

It is desirable that the product also exhibits the following properties;

- 20 b) Particle size measured as mean mass diameter (MMD) less than 30µm, preferably less than 20 µm as determined by laser diffraction technique.
- c) Density between 1.33 g/cm³ and 1.35 g/cm³ as determined by powder pycnometer.
- 25 d) Hygroscopicity not exceeding 2% increase of weight upon storage for one month up to 94% relative atmospheric humidity as determined gravimetrically.
- 30 e) A content of water of between 5% and 10% by weight as determined by titration according to Karl Fischer.

- f) A content of methanol less than 0.1% preferably less than 0.05% by weight as determined by gas chromatography, in case methanol is used as solvent.

In a further aspect, the invention also relates to a process for manufacturing the novel form of magnesium omeprazole. This process is described in more detail below.

The invention relates to all of the aspects given under Field of the invention.

10 The process for producing the novel form of magnesium omeprazole is characterized by the following consecutive steps

- a) treating omeprazole or a salt thereof with magnesium alcoholate in a solution
- 15 b) separating inorganic salts from the reaction mixture
- c) crystallizing magnesium omeprazole
- d) isolating the obtained crystalline magnesium omeprazole and, optionally,
- 20 e) purifying and drying the crystalline magnesium omeprazole using conventional methods.

The process for manufacturing the new product can be described in the following way.

25

A lower alcohol, such as methanol, ethanol, n-propanol or iso-propanol, preferably methanol, is treated in a solution of polar solvents with a weighed amount of magnesium at temperatures between 0°C and reflux temperature. The temperature should preferably be between 10 and 30°C. After addition of the magnesium to the solution the temperature can, in a second step be raised further to between 0°C and reflux temperature, preferably 20-50°C. After termination of the reaction the

30

- temperature is reduced to 0-40°C, preferably 10-25°C. Omeprazole or a salt of omeprazole is then added to the solution and after termination of the reaction the mixture is cooled to -10°C to +20°C, preferably -5°C to +5°C. The solvent is then evaporated to 40-60% of the initial volume, which makes the inorganic salts precipitate. The precipitate is separated from the reaction solution for example by centrifugation or filtration and the solution is heated to 5°C to 30°C whereafter the solution is seeded with magnesium omeprazole crystals. An amount of water, which is approximately equal to the volume of the solution, is added to start the crystallization. The solution is cooled to -10 to +20°C, preferably 0-10°C to complete the crystallization. The crystals are then separated from the mother liquid for example by centrifugation or filtration and washed with polar solvents preferably an aqueous lower alcohol such as aqueous methanol. Finally, the produced crystals are dried preferably under reduced pressure and heating.
- 15 The process for manufacturing the new form of magnesium omeprazole differs from the earlier known processes in that the product is recovered after a controlled crystallization step in aqueous alcohol, preferably methanol by, first, separating the inorganic salts from the mother liquor. The crystallinity resulting from this step is, unexpectedly, higher and the product possesses a higher degree of purity and is
- 20 more stable to decomposition from uptake of moisture. The drying step can be performed without caking. The new process is possible to perform in conventional chemical process equipment and gives a product with a higher yield than the processes hitherto known.
- 25 The following detailed Example 1 will serve to more fully illustrate the process for manufacturing magnesium omeprazole in full scale according to the present invention. In Figures 1 and 2 sample A is manufactured according to this example.

Example 1

A reactor was filled with 2026 litres of methanol. The stirrer was started and the temperature was adjusted to 20°C. 3,90 kg of magnesium was added to the vessel
5 and immediately thereafter 1,0 litre of CH₂Cl₂. The reactor was heated to 40°C and kept at this temperature for 60 min. It was then cooled to 15°C before the addition of 99,9 kg of omeprazole. The reactor was kept at this temperature for 60 min and then cooled to 0°C. The temperature was kept at this level for 30 minutes before 1000 l of methanol were evaporated under vacuum and the inorganic solid
10 salt was separated from the liquid first by centrifugation and then by filtration. The liquid was heated to 10°C and the liquid was seeded with magnesium omeprazole crystals whereafter the magnesium omeprazole salt was precipitated by addition of 900 l of water. The mixture was then cooled to 5°C. After the crystallization had been completed the magnesium omeprazole crystals were centrifuged off and then
15 washed with a mixture of 50 l of methanol and 150 l of water. The produced magnesium omeprazole was dried under reduced pressure finally producing 92,5 kg of crystalline product corresponding to a yield of 81,4%.

The novel form of the magnesium salt of omeprazole according to Example 1
20 possesses the following properties:

- a) Crystalline form, with a degree of crystallinity of 76%, as determined by X-ray powder diffraction.
- 25 b) Particle size measured as mean mass diameter (MMD) of 19µm as determined by laser diffraction technique.
- c) Density of 1.342 g/cm³ as determined by powder pycnometer.
- 30 d) Hygroscopicity of 1.62% increase of weight upon storage for one month at 94% relative atmospheric humidity as determined gravimetrically.

- e) Content of moisture water of 7.6 by weight as determined by titration according to Karl Fischer.
- f) Content of methanol of 0.006% by weight as determined by gas chromatography.

5

A comparison between two different samples of the novel form of magnesium omeprazole of the present invention obtained from two laboratory scale experiments by prior art methods and magnesium omeprazole goes forth from diagrams 1 and 2. In these diagrams sample A represents the novel form of the present invention as manufactured in full scale process equipment. Sample B represents the product of preparation via synthesis by treatment of omeprazole with $\text{Mg}(\text{OCH}_3)_2$. Sample C represents the product of preparation via treatment of sodium omeprazole with MgCl_2 .

15

Figure 1 shows in diagram 1 that the particle size measured as mean mass diameter of the product of method A is 19 μm which is smaller than the corresponding particle size for the products of method B which is 25 μm and of method C which is greater than 600 μm .

20

Figure 2 shows in diagram 2 that the degree of crystallinity of the particles of the product of method A is 76% which is higher than the corresponding figure for the product of sample B, which is 0% and also higher than the corresponding figure of sample C, which 67%.

CLAIMS

1. Magnesium omeprazole characterized in having a degree of crystallinity which is higher than 70% as determined by X-ray powder diffraction.
- 5 2. Magnesium omeprazole according to claim 1 wherein the degree of crystallinity is higher than 75%.
3. Magnesium omeprazole according to claim 1 wherein the mean particle
10 diameter as determined by laser diffraction technique is less than 30 μ m, and preferably less than 20 μ m.
4. Magnesium omeprazole according to claim 1 wherein the density is between 1.33 g/cm³ and 1.35 g/cm³ as determined by powder pycnometer.
- 15 5. Magnesium omeprazole according to claim 1 wherein the hygroscopicity is less than 2% increase of weight upon storage for one month at up to 94% relative atmospheric humidity as determined by gravimetry.
- 20 6. Magnesium omeprazole according to claim 1 wherein the water content is between 5% and 10% by weight as determined by titration according to Karl Fischer.
7. Magnesium omeprazole according to claim 1 containing less than 0.1% by
25 weight of solvent as determined by gas chromatography.
8. Magnesium omeprazole according to claim 1 containing less than 0.05% by weight of solvent as determined by gas chromatography.
- 30 9. A process for the manufacture of magnesium omeprazole according to any of claims 1 to 8 characterized by in consecutive steps

- a) treating omeprazole or a salt thereof with magnesium alcoholate in a solution,
- b) separating inorganic salts from the reaction mixture,
- 5 c) crystallizing magnesium omeprazole,
- d) isolating the obtained crystalline magnesium omeprazole and, optionally,
- e) purifying and drying the crystalline magnesium omeprazole using
10 conventional methods.

10. A process according to Claim 9 wherein the magnesium alcoholate is magnesium methyl alcoholate.

15 11. A process according to claim 9 wherein the solvent is methanol.

12. A process according to claim 9 wherein the crystallization is accomplished by addition of water.

20 13. A process according to claim 9 wherein the isolation of the magnesium omeprazole is performed by centrifugal separation of the crystals.

14. A process according to claim 9 wherein the isolation of the magnesium omeprazole is performed by crystallization followed by filtration of the crystals.

25

15. A process according to claim 9 wherein the purification of the magnesium omeprazole crystals is performed by washing the crystals with a solution of polar solvents.

30 16. A process according to claim 9 wherein the magnesium omeprazole crystals are dried preferably under reduced pressure.

17. A process according to claim 9 wherein the drying of the magnesium omeprazole crystals is performed by evaporating the remaining solvent by heating.
18. Magnesium omeprazole obtained by a process according to any of
5 claims 9 to 17.
19. A pharmaceutical composition containing magnesium omeprazole according to any of claims 1 to 8 as an active ingredient.
- 10 20. A pharmaceutical formulation for oral administration containing magnesium omeprazole according to any of claims 1 to 8 as an active ingredient.
21. A tablet formulation containing magnesium omeprazole according to any of claims 1 to 8 as an active ingredient.
- 15 22. Magnesium omeprazole according to any of claims 1 to 8 for use in therapy.
23. Magnesium omeprazole according to any of claims 1 to 8 for use in inhibiting gastric acid secretion in mammals and man.
- 20 24. Magnesium omeprazole according to any of claims 1 to 8 for use as an agent with gastric mucosa protective activity in mammals and man.
- 25 25. Magnesium omeprazole according to any of claims 1 to 8 for use in the treatment of gastric acid related diseases in mammals and man.
26. The use of magnesium omeprazole according to any of claims 1 to 8 in the manufacture of a medicament for inhibiting gastric acid secretion.
- 30 27. The use of magnesium omeprazole according to any of claims 1 to 8 in the manufacture of a medicament for obtaining gastric mucosa protective activity.

28. The use of magnesium omeprazole according to any of claims 1 to 8 in the manufacture of a medicament for the treatment of gastric acid related diseases.

29. A method for inhibiting gastric acid secretion in mammals and man by
5 administering to a host in need thereof a therapeutically effective dose of
magnesium omeprazole according to any of claims 1 to 8.

30. A method for the treatment of gastric acid related diseases in mammals and
man by administering to a host in need thereof a therapeutically effective dose of
10 magnesium omeprazole according to any of claims 1 to 8.

1
INTERNATIONAL SEARCH REPORT

International application No.
PCT/SE 94/00680

A. CLASSIFICATION OF SUBJECT MATTER

IPC6: C07D 401/12, A61K 31/44
According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC6: C07D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

CAS-ONLINE

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	EP, A2, 0124495 (AKTIEBOLAGET HÄSSLE), 7 November 1984 (07.11.84), see example 5 and 6 -----	1-28

☐ Further documents are listed in the continuation of Box C. ☒ See patent family annex.

* Special categories of cited documents:

- "A" document defining the general state of the art which is not considered to be of particular relevance
- "B" earlier document but published on or after the international filing date
- "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or prior date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance: the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance: the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

7 October 1994

Name and mailing address of the ISA/
Swedish Patent Office
Box 5055, S-102 42 STOCKHOLM
Facsimile No. +46 8 666 02 86

Date of mailing of the international search report
24-10-1994

Authorized officer

Göran Karlsson
Telephone No. +46 8 782 25 00

INTERNATIONAL SEARCH REPORT

International application No.

PCT/SE 94/00680

Box I Observations where certain claims were found unsearchable (Continuation of Item 1 of first sheet)

This international search report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☒ Claims Nos.: 29-30
because they relate to subject matter not required to be searched by this Authority, namely:
A method for treatment of the human or animal body by therapy,
see rule 39.1.
2. ☐ Claims Nos.:
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:
3. ☐ Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box II Observations where unity of invention is lacking (Continuation of Item 2 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest.
☐ No protest accompanied the payment of additional search fees.

INTERNATIONAL SEARCH REPORT
Information on patent family members

27/08/94

International application No.

PCT/SE 94/00680

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
EP-A2- 0124495	07/11/84	SE-T3- 0124495	
		AU-B- 563842	23/07/87
		AU-A- 2525784	06/09/84
		CA-A- 1264751	23/01/90
		GB-A,B- 2137616	10/10/84
		JP-C- 1651336	30/03/92
		JP-B- 3013233	22/02/91
		JP-A- 59167587	21/09/84
		SU-A- 1314953	30/05/87
		US-A- 4738974	19/04/88